

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007983**Date Inspected:** 24-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia, Du Zhi Gun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower&OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY#10

This QA Inspector randomly observed the following work in progress

FCAW welding process of weld joint 63 located on PCMK NSD1-FBSA4-1A/C. Welder is identified as 070046 ZPMC QC is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 64 located on PCMK NSD1-FBSA4-1A/C. Welder is identified as 070140 ZPMC QC is identified as Deng Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 25 located on PCMK NSD1-FESA4-3F/F. Welder is identified as 068864 ZPMC QC is identified as Du Zhi Gun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 26 located on PCMK NSD1-FESA4-3F/F. Welder is identified as 066683 ZPMC QC is identified as Du Zhi Gun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

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FCAW welding process of weld joint 55 located on PCMK NSD1-TC8H/L. Welder is identified as 068865 ZPMC QC is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B-TC-F-2.

FCAW welding process of weld joint 57 located on PCMK NSD1-TC8H/L. Welder is identified as 070212 ZPMC QC is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B-TC-F-2.

FCAW welding process of weld joint 56 located on PCMK NSD1-TC8H/L. Welder is identified as 068865 ZPMC QC is identified as Shi Jing Wei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-TC-F-2.

BAY#11

SMAW welding process of weld joint 4A located on PCMK WSD1-FDSA4-4A/D. Welder is identified as 040690 ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) Repair.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-3AE

FCAW welding process of weld joint 004 located on PCMK SSD17-PP021. Welder is identified as 050242, 051356 ZPMC QC is identified as Zhong Hai Tao. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

This QA Inspector observed ZPMC performing Magnetic particle Inspection on the weld gouged excavation area on the weld joint between Deck panel diaphragms to floor beam flange (SSD018A-PP22-005).

OBG SEGMENT-2BW

This QA Inspector observed ZPMC performing Air arc gouging on the weld joint between longitudinal diaphragms to the bottom panel at PP18.

OBG SEGMENT-4AE

FCAW welding process of weld joint 004 located on PCMK SSD19-PP024. Welder is identified as 050242, 051356 ZPMC QC is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

This QA Inspector observed ZPMC performing Magnetic particle Inspection on the weld gouged excavation area on the weld joint between Deck panel diaphragms to floor beam flange (SSD020-PP25-005).

WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC performing Air arc gouging on the weld joint between Deck panel diaphragms to floor beam flange (SSD19-PP24-005).

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang + (86) 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
